

Split

Work Order ID 74301-2



Page 1

Wednesday, September 28, 2011 10:46:22 A

Item ID: D4092-041

Accept



Setup Start



Revision ID: ~~041~~ 041 11639

Stop



Item Name: Maintenance Step Assembly

Start Date: 9/28/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4092

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg
Torque screws up to 15-25 in- lbs

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Paul/10/19

Paul/10/20

(x3)

8/10/21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74301

Page 2

Wednesday, September 28, 2011 10:46:22 A

Item ID: D4092-041

Accept



Setup Start



Revision ID: U/R

Stop



Item Name: Maintenance Step Assembly

Start Date: 9/28/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPN74002

0.00

Packaging

11/14/21 (3)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/24 JF

MF

11-10-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 28, 2011 10:46:18 AM

Page 1

Work Order ID: 74301

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly



Start Date: 9/28/2011

Required Date: 10/14/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD IPP
REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4092-1		Manufactured	No			100	Each	0.0000	2	10			
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Maintenance Step

D4093-1		Manufactured	No			100	Each	0.0000	1	5			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Bracket

D4093-3		Manufactured	No			100	Each	0.0000	1	5			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Bracket

D4093-5		Manufactured	No			100	Each	6.0000	2	10			
---------	--	--------------	----	--	--	-----	------	--------	---	----	--	--	--



Bracket

Location

Loc Qty

Loc Code

ST124

6

62569

6

MS24694-S54

Purchased

No

100

Each

148.0000

2

10



Screw

Location

Loc Qty

Loc Code

ST289

100

118078

100

ST289A

48

117677

48

117679

11/10/11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 28, 2011 10:46:19 AM

Work Order ID: 74301

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 9/28/2011

Required Date: 10/14/2011

Start Qty: 5.00

Required Qty: 5.00

MS24694-S55 Purchased No 100 Each 61.0000 8 40



Screw

19

Location

Loc Qty

Loc Code

ST289A

61

M119307

21

13884

61

13884 21x

MS24694-S56 Purchased No 100 Each 56.0000 2



SCREW

Location

Loc Qty

Loc Code

ST289A

56

104407

56

104407

NAS1149D0332J Purchased No 100 Each 2,907.000 12



Washer

Location

Loc Qty

Loc Code

ST297

869

117087

869

117087

ST298

1038

105793

12

118078

26

118384

1000

ST302

1000

119042

1000

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, September 28, 2011 10:46:19 AM

Page 3

Work Order ID: 74301

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly



Start Date: 9/28/2011

Required Date: 10/14/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L3

Purchased

No

100

Each

8,399.000

12

60



Nut



Location

Loc Qty

Loc Code

ST300

2399

117441

16

117601

240

117885

143

118451

1000

118927

1000

ST516

6000

119017

6000

118927

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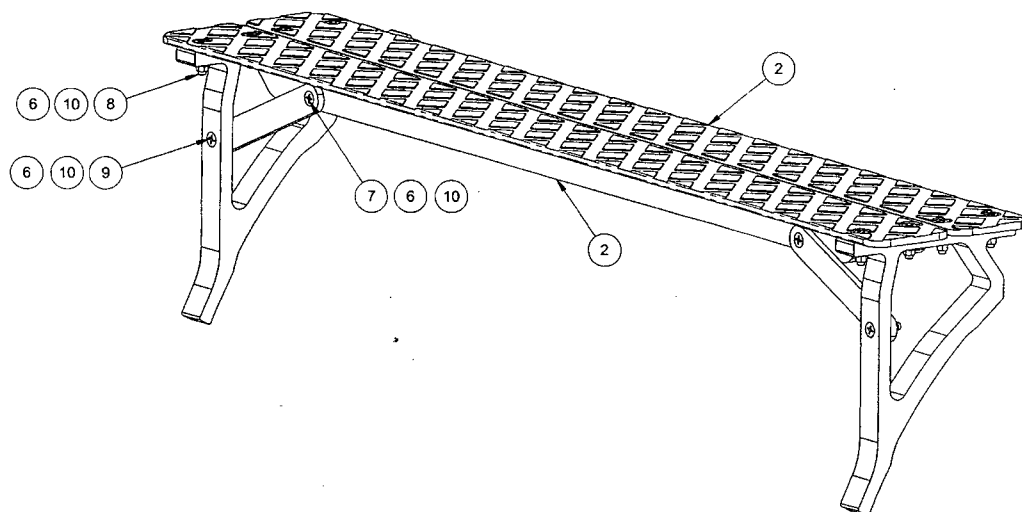
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D4092-041 MAINTENANCE STEP ASSEMBLY

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

RELEASED
2011-09-22

B	REDRAWN; LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 1 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASS'Y	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ORIGIN OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O 74301

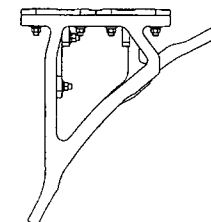
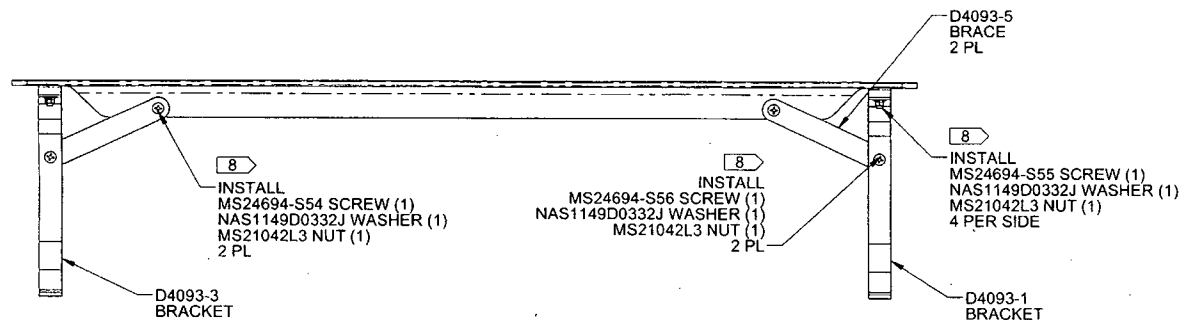
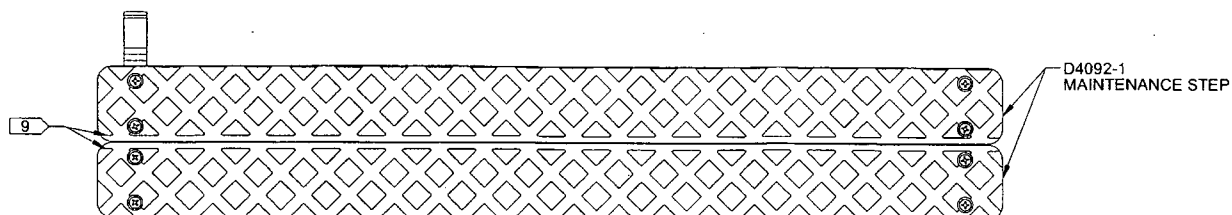
Dart Aerospace Ltd

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D4092-041 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

RELEASED
2011-09-22

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	NTS
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